

Date: Tuesday, 29/04/2008 9:59:51 AM  
 User: Melanie Fauteux

## Process Sheet

OK

Customer :	CC-DAR01 Dart Aerospace Ltd.	Drawing Name :	UPPER RAIL
Job Number :	38866	Part Number :	D37671
Estimate Number :	10804	Drawing Number :	PROTOTYPE
P.O. Number :		Project Number :	
This Issue :	29/04/2008	Drawing Revision :	A 08.04.23
Prsht Rev. :	NC	Material :	
First Issue :	29/04/2008	Due Date :	16/05/2008
Previous Run :	00015	Qty:	2
Written By :		Unit:	Each
Checked & Approved By :			
Comment :			

## Additional Product

PROTOTYPE

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

MAKE PER DRWG D3767 REV A

FF 08-05-12 (2)

2.0

M6061T6T1000W065

6061T6 TUBE



Comment: Qty.: 2.9300 f(s)/Unit Total: 5.8600 f(s)

6061T6 TUBE

M 107950

FF 08-05-08 (2)

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING  
APPROVAL

08/05/12 (XB) / 08.05.14

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

ACID ETCH AND ALODINE PER QSI 005

- 22 / M-L 08/05/14 (2X)

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

CERTIFICATE OF CONFORMITY  
REQUIRED

08.05.14

Date: Tuesday, 29/04/2008 9:59:51 AM  
User: Melanie Fauteux

## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: UPPER RAIL

Job Number: 38866

Part Number: D37671

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

GIVE TO CHRIS P-ENG

FOR ENGINEERING USE ONLY

RE 06.05.29

CHARGE TO JOB #00196

7.0

QC21

FINAL INSPECTION/W/O RELEASE



CERTIFICATE OF CONFORMANCE  
REQUIRED



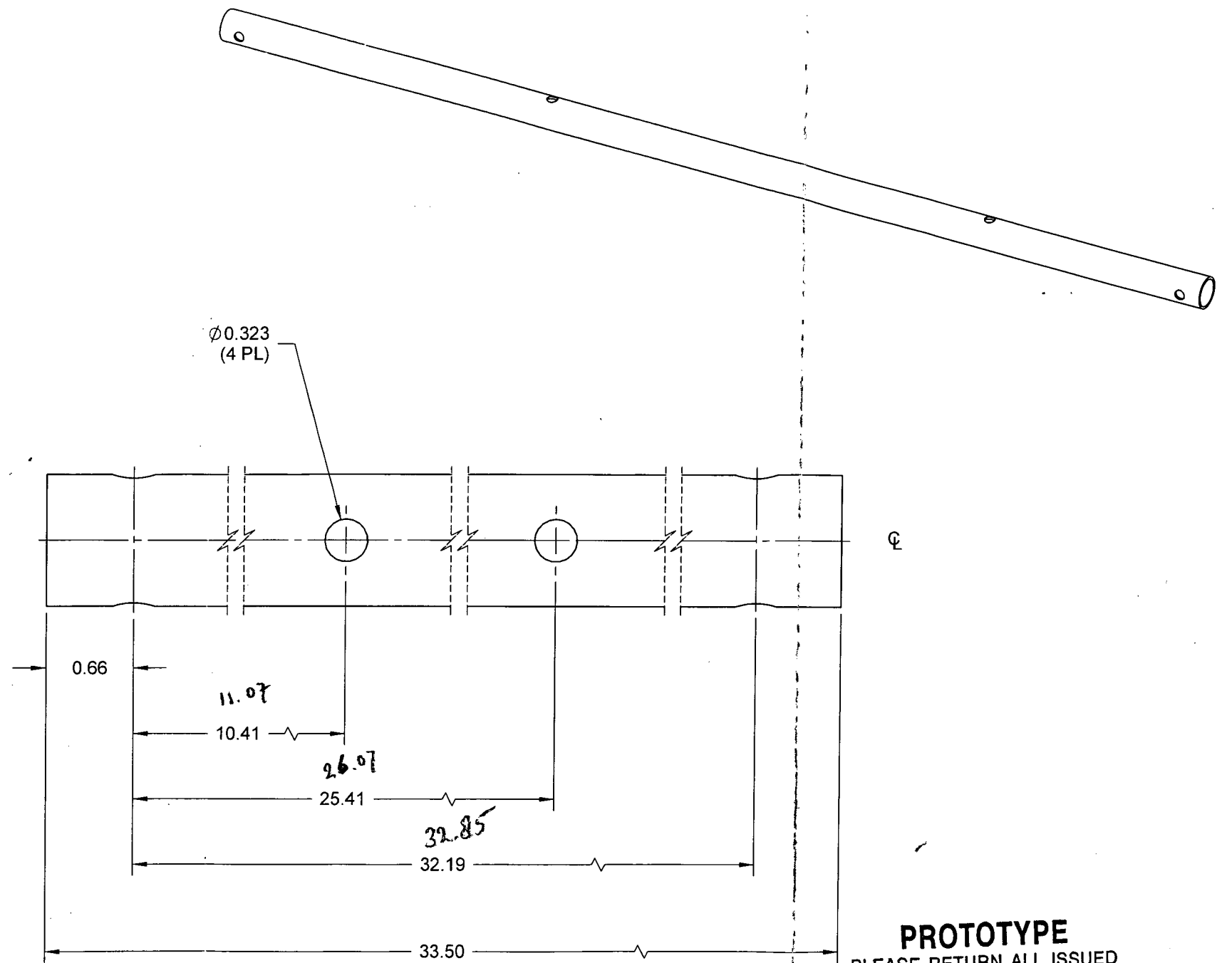
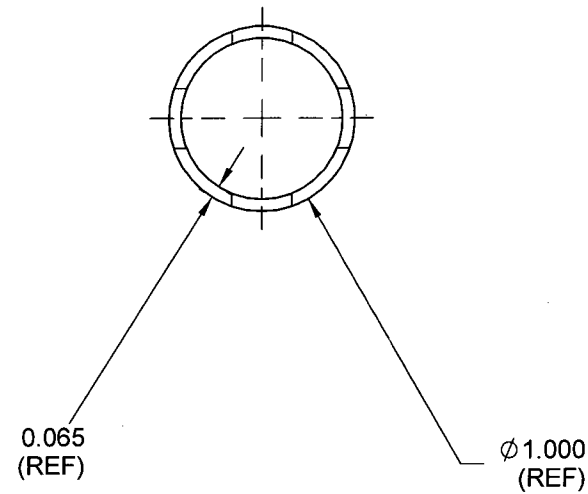
Comment: FINAL INSPECTION/W/O RELEASE

08.05.29 Perry

Job Completion



U 08.06.11



**D3767-1 UPPER RAIL**

**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING

*UP 080423*

**NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) ALUMINUM TUBING 1.00" X 0.065" WALL (REF. DART SPEC. M6061T6T1.000W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.62 lbs

DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D3767</b>	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		<b>UPPER RAIL</b>	1:1
DATE	<b>08.03.26</b>	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

# Receiving Report

Date: 8/5/6  
Supplier: MARNER

Batch No: M107950  
Dart P/O: 6269

Packing Slip: Yes ☒ No ☐  
Invoice: Yes ☐ No ☒  
Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐  
Waybill Attached: Yes ☒ No ☐ N/A ☐  
Shipment Complete: Yes ☒ No ☒ N/A ☐  
QC6 Inspection ☒ 6/20/08 N/A ☐  
Work Order ☐ N/A ☒

## Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12 CU

Production/Admin:

Date: 08/05/08  
Received/Costing: R/R 7822  
Initial: CR

Location: \_\_\_\_\_

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

RECEIVED MAY 09 2008

Energy Surcharge

12.20

ORIGINAL INVOICE / FACTURE ORIGINALE

G.S.T. /HST T.P.S.	18.02
PROVINCIAL TAX TAXE PROVINCIALE	.00

378.38

06/04/2008

PAYMENT OF THIS INVOICE IS DUE BY  
LE RÈGLEMENT DE CETTE FACTURE EST EXIGIBLE AU PLUS TARD LE

FEB 18 2008 15:44 FR MARMON KEYSTONE

6309722464 TO 14506414357

P.02/03

02/18/2008 From: MARMON/KEYSTONE  
M/K OR:  
C.P.O.:  
C PART:

INIT.:

To:

OR. REF:  
SLSPRS:

# KAISER ALUMINUM FABRICATED PRODUCTS

KAISER ALUMINUM  
FABRICATED PRODUCTS  
6573 W. WILLIS ROAD  
CHANDLER, AZ 85226

**CERTIFIED TEST REPORT**  
<http://www.KaiserAluminum.com>

CUSTOMER PO NUMBER: 80-33603		CUSTOMER PART NUMBER: AT/1.065/734		PRODUCT DESCRIPTION: Seamless Tube	
KAISER ORDER NUMBER: 200438	LINE ITEM: 005	SHIP DATE: 11/27/2007	KAISER LOT NUMBER: F00000606	ALLOY: 6061	TEMPER: T6
WEIGHT SHIPPED: 331.000 LB	QUANTITY: 123.000 PCS	BL NUMBER: 200274	DIA/DEPTH/THK: 12.000 FT	WIDTH:	LENGTH:
SHIP TO: MARMON/KEYSTONE CORP 10700 MARMON DR BOLINGBROOK, IL 60440 USA			SOLD TO: MARMON/KEYSTONE CORP 10700 MARMON DR BOLINGBROOK, IL 60440 USA		

## Actual Physical Properties

REFERENCE	DASH	SAMPLES	UTS (KSI)	YTS (KSI)	ELONG%	HARDNESS	CORREL	REMARK
F00000606	0001	1	46.5	42.6	17.0	N/A	N/A	N/A

## Chemical Composition (wt%), Aluminum Remainder

LIMITS	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Bi	Er	Ea	Tot
Maximum	0.80	0.70	0.40	0.15	1.20	0.35	0.25	0.15	NA	NA	NA	0.05	0.15
Minimum	0.40	0.00	0.15	0.00	0.80	0.04	0.00	0.00	NA	NA	NA	0.00	0.00
A22452	.62	.39	.22	.05	.92	.06	.03	.02	.00	.01	.00	.00	.00

## CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC ('Kaiser') hereby certifies that metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms conditions of sale. Test reports are on file subject to examination.

Wilfredo A. de la Cruz, Sr. Metallurgical Engineer

Plant Serial: 00000264

Kaiser Order Number: 200438

Line Item: 005

Page 1 of 2

FEB 05 2008 13:10

AT 1.065 734

**Q.C. REVIEWED**

PAGE 02

18 2008 15:44 FR MARMON KEYSTONE

6309722464 TO 1450641457

2/2008 From: MARMON/KEYSTONE  
OR:  
C.P.O.:  
C PART:

INIT.:

To:

OR. REF:  
SLSPRS:

# KAISER ALUMINUM

FABRICATED PRODUCTS

KAISER ALUMINUM  
FABRICATED PRODUCTS  
6573 W. WILIS ROAD  
CHANDLER, AZ 85226

CERTIFIED TEST REPORT  
<http://www.KaiserAluminum.com>

## Applicable Requirements:

Description: OD: 1.000"; Wall: 0.065"; Round @  
AMS-4082N ASTM-B210-04 WW-T-700/6F  
WE TAKE EXCEPTION TO PARA. 5.2.1. Per AMS 4082N, WAS NOT OILED.  
THE FOLLOWING SPECIFICATION HAVE BEEN MADE INACTIVE OR  
CANCELLED: MIL-T-7081, WW-T-700F/GEN, WW-T-700/2E, WW-T-700/3F,  
WW-T-700/4F, WW-T-700/5E, WW-T-700/6F, WW-T-700/7E.  
COMPLIES TO THE REQUIREMENTS OF DIN EN 10204  
COMPLIES TO DIN EN 10204 JAN 2005

## Miscellaneous Notes

MANUFACTURED IN USA MELTED IN USA

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Wilfredo A. de la Cruz, Sr. Metallurgical Engineer

*Wilfredo A. de la Cruz*

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Plant Serial: 00000264

Kaiser Order Number: 200438

Line Item: 005

FEB 06 2008 13:11

PAGE.03

\*\* TOTAL PAGE.03 \*\*